

# Work Order ID 71630

Thursday, July 07, 2011 11:21:44 AM



Page 1

Item ID: D3259-1

Accept



Setup Start



Revision ID:

Item Name: Panel

Stop



Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: CMF

Date: 11-07-07 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3259	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3259 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

2024.032

B 11-8-15

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 11-8-15

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S wloski

(410)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Setup Start



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Stop



Item Name: Panel

Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00

Customer:

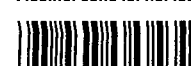
Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

10 0 11/08/16

140



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

10X 0 M-1 11/08/16

150



Packaging

Identify as per dwg & Stock Location: 180A

0.00

Memo

0.00

Packaging

11/8/17 5 100

W/O:		WORK ORDER CHANGES					
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**Work Order ID 71630**

Thursday, July 07, 2011 11:21:44 AM



Page 3

Item ID: D3259-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel

Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/18 [Signature]

11/16 08-18  
10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 07, 2011 11:21:41 AM

Page 1

Work Order ID: 71630



Parent Item: D3259-1



Parent Item Name: Panel



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV  
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032 		Purchased		No		100	sf	24.4000	1.388	11.68842		14.	
2024-T3 .032 sheet												B11-8-15	

Location

Loc Qty

Loc Code

MAT22

24.4

111699

0.5

113189

23.9

113189

(10)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 71636
<b>Description:</b> Panel		<b>Part Number:</b> D3259-1
<b>Inspection Dwg:</b> D3259	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.188	+/-0.010	?				
1.000	+/-0.005	.999	x		V B02	
9.000	+/-0.005	8.999	o		PROW302	
R0.50	+/-0.030	.50	o		R.G	
0.875	+/-0.005	.877	?		V	
5.000	+/-0.005	5.001	o		V	
R0.13	+/-0.030	.13	?		R.G	
17.125	+/-0.010	?			-	
12.000	+/-0.005	12.002	o		P	
3.500	+/-0.005	3.502	r		V	
0.875	+/-0.005	.872	x		V	
1.745	+/-0.010	1.748	?		V	
0.260	+/-0.010	.260	r		V	
2.150	+/-0.010	2.158	?		V	
1.800	+/-0.010	1.808	r		V	
0.250	+/-0.010	.252	?		V	
1.750	+/-0.010	1.758	?		V	
Ø0.098	+0.005/-0.000	.101	?		V	

<b>Measured by:</b> B	<b>Audited by:</b> J	<b>Preliminary Approval:</b>
<b>Date:</b> 11-8-15	<b>Date:</b> 11/08/16	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	
B	10.06.07	Dwg Rev updated	KJ	

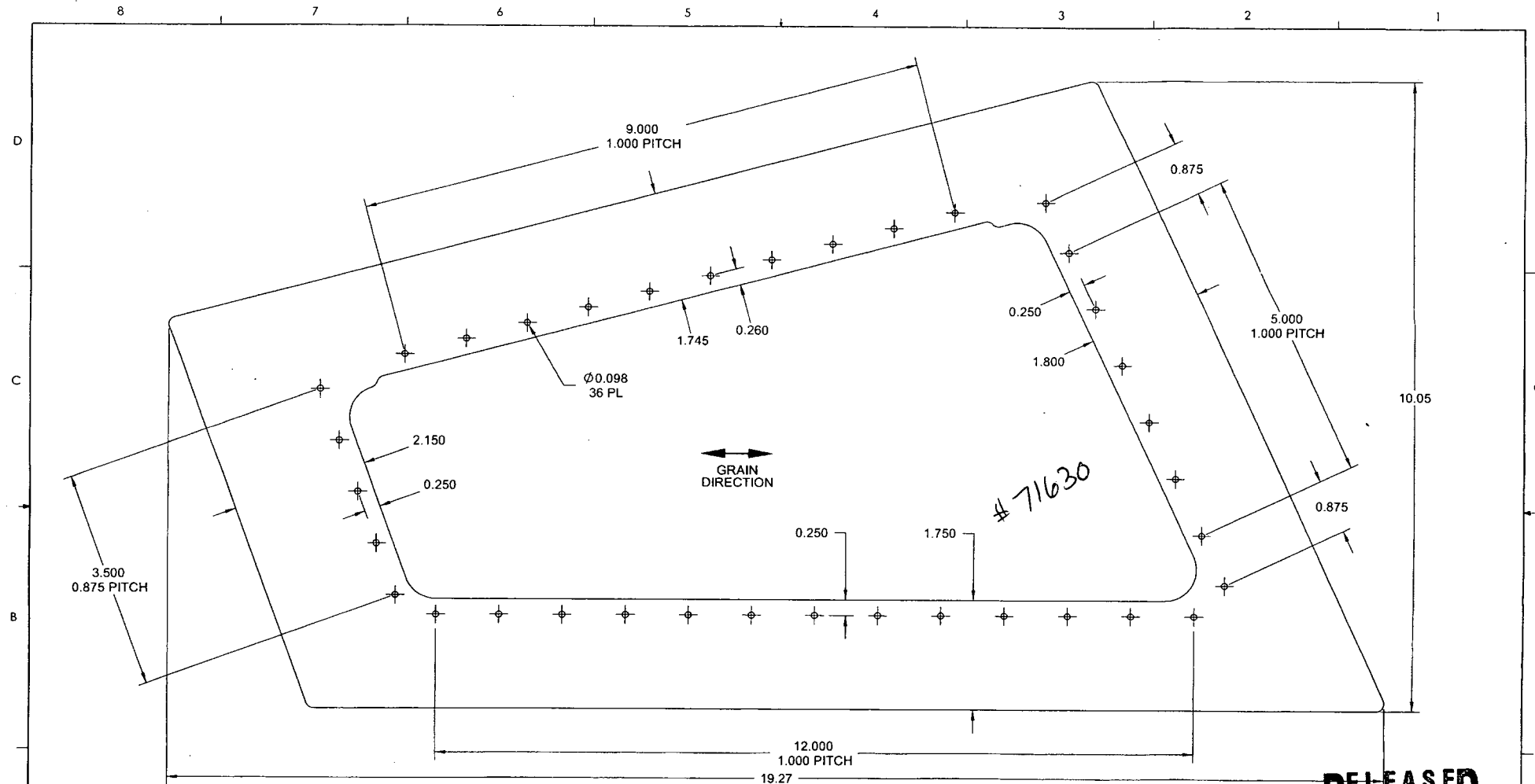
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**D3259-1 PANEL**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.25 lbs
- 8) MAKE PER DWG FILE "D3259-1B.DXF"

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3259	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSEMBLY	NTS
DATE	09.08.12	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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**RELEASED**  
2009-10-08  
MNO

W/O:		WORK ORDER CHANGES					
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